	ler ID 60: ly 14, 2010 8:2					1			:		Page
tem ID: Revision ID:	D4016-3			Accept				i s	Setup Sta	art	
tem Name:	Hinge Half, Li	id	1 100(10 MILL 100)			1			St	ор	
Start Date: Required Date Reference:	7/14/2010 e: 7/22/2010	Start Qty: 6.00 Req'd Qty: 6.00			Cust Iter Custome			1			
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):		Date:		.			
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool II	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr				1	:			:	
D4016	A			**		' . :					
100 Bandsaw Jeaspa Bandsaw		Cut blanks as per folio Memo CUT BLAN	K as per folio	0.00 0.00	10/07/17	Z		6	ø		-
110 HAAS 1 HAAS CNC vertica	val machine #1	Memo MACHINE FOLIO REV DWG REV	AS PER FOLIO FA874 AN	0.00 0.00	L10/07/12	S		_6	<i>B</i> :		· · · · · · · · · · · · · · · · · · ·

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W/O:			W	ORK ORD	ER CHANG	GES					
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Part No	:	PAR #:	Fault Ca	tegory:		NCF	R: Yes N	lo DQA	:	Date: _	 .
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Page 2

Wednesday, July 14, 2010 8:20:43 AM

Item ID:

D4016-3

Revision ID: Item Name:

Hinge Half, Lid

Start Date:

7/14/2010 Required Date: 7/22/2010

Start Qty: 6.00 Req'd Qty: 6.00



Date:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop



Sequence ID/

Work Center ID

120

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours**

ml 10/07/18 0.00

Tool ID Tool # Plan

Accept Code Qty

Reject Qty

Run

Reject Number

Insp. Stamp

130

QC

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

0.00

Quality Control

Identify as per dwg & Stock Location-

0.00

WA

Memo

10.719

Packaging Packaging

160

0.00

W/O:			WO	RK ORDER CHANG	ES	·			
DATE	STEP	PRO	OCEDURE CHAI		Ву	Date	Qty Approval Chief Eng / Prod Mgr QC Ins		
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DATE		Description of NC	<u> </u>	Corrective Action Section B			tion	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	Section Section	Section C Chief E		QC Inspector
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Work Order ID 60548

Wednesday, July 14, 2010 8:20:43 AM



Page 3

Item ID:

D4016-3

Accept



Setup Start

Stop



Revision ID: Item Name:

Hinge Half, Lid

Start Date: 7/14/2010

Required Date: 7/22/2010

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference: Approvals:

Process Plan: _____

Date:

Tooling:

Date:

Run Start

QC:

Date:_

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

170

Operation Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code: Qty

Reject Accept Qty.

Reject

Insp. Number Stamp

Quality Control

								-		
W/O:			WC	ORK ORDER CHAN	IGES					
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Picklist Print

Wednesday, July 14, 2010 8:20:47 AM

Work Order ID: 60548

Parent Item: D4016-3

Parent Item Name: Hinge Half, Lid

Start Date: 7/14/2010

Start Qty: 6.00

Required Date: 7/22/2010

Page 1

Required Qty: 6.00

Comments:

I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD

per dwg REV.A DD 10.02.22 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty p	er Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	15.6177		.08	0.505263	•		
304 bar 1.00 x 1.00							ſ			'				

Location MAT54

113290

15.61774168 15.6177417

Loc Qty

i i

Loc Code

0505263 Onfidotia

13.0177417

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W/O:			V	ORK ORDER CHANG	ES					
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	R	esolution:	_ Disposit	ion:	_ QA	: N/C Clo	sed:		Date:	
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DART AEROSPACE LTD	Work Order:	60548
Description: Hinge Half, Lid	Part Number:	D4016-3
Inspection Dwg: D4016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	-875	/			
0.13	+/-0.030	.128				
0.250	+/-0.010	.250	/			
R0.03	+/-0.030	R.030	\			
0.13	+/-0.030	,128	\			
0.50	+/-0.030	. 499	\			
0.63	+/-0.030	.625				
0.563	+/-0.010	.562	1			
Ø0.257	+0.006/-0.001	Ø.258	1			
						-
						•

Measured by:	aml	Audited by:	mv-	Preliminary Approval:	
Date:	10/07/18	Date:	10/07/18	Date:	

Rev	Date	Change	Revised by ∧	Approved
Α	10.06.07	New Issue	KJ 97()	<u> </u>
	<u> </u>			

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Part No	•	······	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA:	Date: _	
Resolution: Disposition:						_ QA: N/C Cld	sed:	Date: _	
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DATE	CTED		Description of NC			tion B	Verification	Approval	Approval
DATE	STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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D4016-1 HINGE HALF, BASE

D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 60578

RELEASED 2010 -02- 16

Α	NEW ISS	SUE	1	JPH	10.01.29
REV.			DESCRIPTION	BY	DATE 4
DESIG	N	AJS	DART AEROS	PACEL	חז
DRAW	N .	AJS	HAWKESBURY, ON		
CHECK	ŒD	a	DRAWING NO.		REV. A
MFG. A	PPR.	1/2	D4016		SHEET 1 OF
APPRO	VED	10.	TITLE		SCALE
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- 0.875 0.25 0.38+0.03 R0.38 REF Ø0.257 THRU GRAIN DIRECTION 0.88 0.50 0.13 R0.03 -- 0.75 -

D4016-1 HINGE HALF, BASE

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART, SPEC M304B

-5: 6061-T6/T6510/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QC-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-5: 0.01 lbs

0.63 THRU **D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID**

0.563 -

GRAIN DIRECTION

0.50

0.13

0.250

R0.31 REF



DESIGN	AJS	DART AEROSPACE LTD						
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA						
CHECKED	0	DRAWING NO.	REV. A					
MFG. APPR.	77	D4016	SHEET 2 OF 2					
APPROVED	10	TITLE	SCALE					
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DATE 10.0	1.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOGUMENT IS PRIMATE AND COMPORTULE AND IS SUPPLED ON THE EMPESS CONDITION THAT IT IS ROT TO BE VISID FIGH ANY PAINAGE OF COMPORTULE AT THE ANY PAINAGE WITHOUT WRITTEN MY BURISDED FIGH ANY PAINAGE ANY WITHIN MY BURISDED FIGH ANY PAINAGE STO						

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